



Dart Aerospace Ltd.
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K6A 1K7
Canada

Tel (613) 632-5200
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D5770-043**Job Sheet 208151****Part No:** D5770-043**Job Qty:** 2 pcs**Part Name:** Handle Hoop**Part Weight:** 0 lbs**Job Created:** 3/12/20**Due Date:** 3/24/20**Type:** Stock**Note:** URF 20-522 DWG 5770 REV.A IPP REV:A NEW ISSUE 20.01.14 JV VERF:DD**Ship Via:****POSITIVE RECALL**EFFECTIVE 2/13/12 AUTH SAD

Status: New

DATE

Priority: Medium

Job Tracking No:**Created By:** Jennifer Renwick**Description:**

POSITIVE RECALL

Bill of Materials**Job Routing**

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Large Fab - Welded Assy-1	2 pcs	3/24/20	3/24/20	0.00	1.00	Large Fab - 1		
							Large Fab - 10		
							Large Fab - 2		
							Large Fab - 3		
							Large Fab - 4		
							Large Fab - 5		
							Large Fab - 6		
							Large Fab - 7		
							Large Fab - 8		
							Large Fab - 9		
							Large Fab - 11 (Various)		MA
							Large Fab - 12		
110	QC 10	2 pcs	3/24/20	3/24/20	0.00	0.00	QC 10 - 10		
							QC 10 - 18		
							QC 10 - 24	DAS	
							QC 10 - 43	24	
							QC 10 - 50	9-89	
							QC 10 - 58		
							QC 10 - 9		
							QC 10 - 68		
120	QC 5	2 pcs	3/24/20	3/24/20	0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19	DAS	
							QC 5 - 22	24	
							QC 5 - 24	9-89	
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		

**Container No:** S267891**Part:** D5770-043**Job No:** 208151**Serial No/Batch:** S267891**Revision:** REV.A**Inspector:****Exp Date:****Instructions:** Various STC's

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CANADA
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Email: sales@dartaero.com
www.dartaerospace.com

Date: 03/31/20

Plex 3/12/20 8:55 AM Dart.Renwick.Jennifer

				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
				QC 5 - 61	
				QC 5 - 81	
130 Packaging 3-1 - Stock - B4B 2 pcs	3/24/20	0.00 0.00		Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
				Packaging 3 - 37 - B4B	
140 QC 21 - SA 2 pcs	3/24/20	0.00 0.00		QC 21 - SA - 21	
				QC 21 - SA - 70	
				QC 21 - SA - 53	

DAS
24
9-89

APR 02 2020

Part Op 100 - 1- Drill holes with DT10651 as per dwg D5770-3 2- Deburr 3- Weld bushing as per dwg D5770-043 Weld per dwg
 Descriptions: ~~ER70S-2~~ or ER70S-6 106 Batch, 4- Grind welds flush *No Filler Rod, Fuse Weld*
 110 - (QC10- Inspect visual per QSI004- ground welds)
 120 - (QC5- Inspect part completeness to step on W/O)
 130 - Identify as per dwg & Stock Location: See note 6.
 140 - (QC21- Final Inspection - Work Order Release)

M139022

MU # 015280

Job BOM

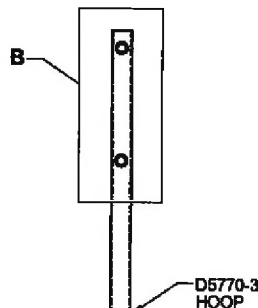
Part / Item	Component Name	Quantity	Operation	Container
D5770-5	Hoop	2 pcs (1 ea)	100-Large Fab - Welded Assy-1	5261807
D5770-9	Bushing	4 pcs (2 ea)	100-Large Fab - Welded Assy-1	5259373

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Large Fab - Welded Assy-1	D5770-5	2	10	0
	D5770-9	4	12	0
Part Specifications				
Specifications could not be found.				

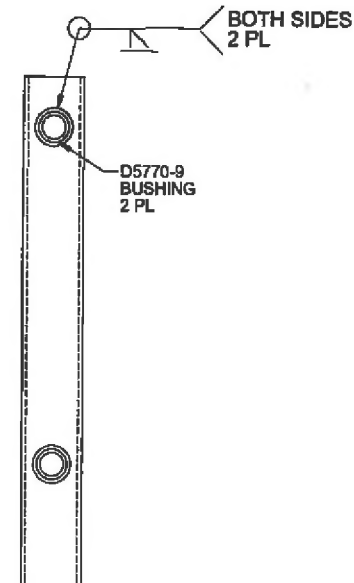
Plex 3/12/20 8:55 AM Dart.Renwick.Jennifer

QTY -043	P/N	DESCRIPTION
X	D5770-043	HANDLE HOOP
1	D5770-3	HOOP
2	D5770-9	BUSHING

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 208151



D5770-043 HANDLE HOOP
(DERIVED FROM AERO DESIGN P/N 84262-01)



DETAIL B
SCALE 3X

UNDER REVIEW

URF 2020-522 20.02.14 (NO)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY PER DART QSI 044
- 7) WEIGHT: 0.86 lbs
- 8) WELD PER DART QSI 004

RELEASED
2020 FEB 18 *NO*

APPROVED

DESIGN	ZF	DART AEROSPACE LTD	
DRAWN	ZF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	KPT	DRAWING NO.	REV. A
MFG. APPR.	DD	D5770	SHEET 2 OF 7
APPROVED	NO	TITLE	SCALE
DE APPR.	CP	BASKET HOOPS	NTS
DATE	20.01.09	<small>COPYRIGHT © 2002 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE LOANED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION OF DART AEROSPACE LTD.</small>	

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/>	DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Cross tube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> </div> <div> Eng. (Non-AW) <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Water Jet <input type="checkbox"/> Supplier <input type="checkbox"/> Quality <input type="checkbox"/> </div> </div>			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QS1042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause <div style="display: flex; flex-direction: column; align-items: flex-start;"> <div>Operator <input type="checkbox"/></div> <div>Manufacturing Process <input type="checkbox"/></div> <div>Equip/Tooling <input type="checkbox"/></div> <div>Handling/Presservation <input type="checkbox"/></div> <div>Material <input type="checkbox"/></div> <div>Product Improvement <input type="checkbox"/></div> <div>Process Improvement <input type="checkbox"/></div> <div>Human Factors <input type="checkbox"/></div> </div>		FAULT CATEGORY <div style="display: flex; flex-wrap: wrap;"> <div style="width: 50%;"> <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Bending <input type="checkbox"/> Crushing <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave/Twist <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Mislabeled </div> <div style="width: 50%;"> <input type="checkbox"/> Contamination <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Incomplete/Unclear Instructions <input type="checkbox"/> Drill Holes <input type="checkbox"/> Fit/Function </div> <div style="width: 50%;"> <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain Direction <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Off-set/Set-up </div> <div style="width: 50%;"> <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Outside Tolerance <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Misread </div> </div>			
Other/Details:					